

Bould

In accordance with yet another embodiment of the invention, the apertures 58 of the recesses 56 are formed after the structure 50 is removed from the mold assembly.

IN THE CLAIMS:

(As per 37 C.F.R. § 1.121 amended claims are provided below in clean form with a marked-up version attached in Appendix A.)

Please substitute claim 1 with amended claim 1, submitted herewith:

- BA*
1. (Once amended) A method for blow molding large parts, comprising the steps of:
- providing a reinforced plastic melt comprising at least one thermoplastic material and reinforcement particles dispersed within the at least one thermoplastic material, the reinforcement particles comprising less than 15% of a total volume of the plastic melt, at least 50% of the reinforcement particles having a thickness of less than about 20 nanometers, and at least 99% of the reinforcement particles having a thickness of less than about 30 nanometers;
 - communicating a tubular formation of said plastic melt to a mold assembly having a mold cavity defined by mold surfaces, said mold surfaces corresponding to a configuration of the part to be molded, an amount of said plastic melt communicated to said mold assembly being sufficient to form a part having a weight of at least 2 pounds and a total surface area of at least 400 sq. inches;
 - applying pressurized gas to an interior of said tubular formation to expand said tubular formation into conformity with said mold surfaces;
 - solidifying said plastic melt to form said part; and
 - removing said part from said mold assembly.
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Please substitute claim 4 with amended claim 4, submitted herewith:

B3 4. (Once amended) A method according to claim 3, wherein said support structure further includes another pair of recesses constructed and arranged to mount parking lights therein.

Please substitute claim 8 with amended claim 8, submitted herewith:

B4 8. (Once amended) A method according to claim 1, wherein said part comprises a substantially hollow,

bumper for a motor vehicle, said method further comprising:

mounting said bumper to an exterior of the motor vehicle at an end of the motor vehicle;

communicating an interior of said bumper to a fluid consuming component of the motor vehicle; and

filling said bumper with fluid to enable said bumper to serve as a fluid reservoir for said fluid consuming component.

Please substitute claim 13 with amended claim 13, submitted herewith:

13. (Once amended) A method for blow molding large parts, comprising the steps of:

providing a reinforced plastic melt comprising at least one thermoplastic material and reinforcement particles dispersed within the at least one thermoplastic material, the reinforcement particles comprising less than 15% of a total volume of the plastic melt, at least 50% of the reinforcement particles having a thickness of less than about 20 nanometers, and at least 99% of the reinforcement particles having a thickness of less than about 30 nanometers;

communicating a tubular formation of said plastic melt to a mold assembly having a mold cavity defined by mold surfaces, said mold surfaces corresponding to a configuration of the part to be molded, an amount of said plastic melt communicated to said mold assembly being sufficient to form

a part having a weight of at least 2 pounds and a total surface area of at least 400 sq. inches;

applying pressurized gas to an interior of said tubular formation to expand said tubular formation into conformity with said mold surfaces;

solidifying said plastic melt to form said part; and

removing said part from said mold assembly,

said part comprising a substantially hollow, integrally formed bumper and radiator and light support structure assembly for a motor vehicle, said method including

forming a radiator frame portion of said integrally formed assembly, and forming apertures in said frame portion for securing a motor vehicle radiator to said support structure,

forming a pair of light receiving recesses of said integrally formed assembly constructed and arranged to mount lights for said motor vehicle, and forming apertures in said recesses for securing said lights to said support structure; and

forming a bumper portion of said integrally formed assembly; and

mounting said assembly on the front end of the motor vehicle.